Work Order May-13-13 1:13:59		776 p 3 8 8	3-1		*101	1776*							Page 1
Revision ID:	883-1	B101		A	Accept	*N9000	14 0 ·	100)*	Setup St	tart top	*NS	S1* S2*
Start Date: 5/1 Required Date: 5/2 Reference:	4/13 20/13	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Item II Customer:) :						
	rocess Plai	n: MC5		13-05-14	Tooling: _ SPC (Y/N):	Dai			I		tart top	*NI *NI	R1* R2*
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp
Draw Nbr	Revi	sion Nbr											
D3883	С	:	· · · · · ·										
*100 *100 HAAS 1 HAAS CNC vertical ma	chine #1	Double ch 1-Machine Sheets 2-Machine 3-Machine	eck by: Step No 1 po Step No 2 po Step No 3 po PER DWG A	1776 er Folio FA815 a er Folio FA641ar	0.00 0.00 nd inspect per attached in the dispect per Dimens	Dimension Sheets	13/07	7/15	6	*	-		<u> </u>
105 *105* Mill Conv Conventional Milling M	1achine	Memo MILL KE	YWAY AS PI	ER DWG	0.00 0.00	AS 40 9-89	13/07	1/15	le	B			J 13-7-10

NCR: Y	es / No				WORK ORDER NON-C		IFORN	MANCE / UPI	DATE			
	,								10 F	QA Closed:	Date	
Work Orde	er:				DISPOSITION			,	AGAINST DE	PARTMENT	/PROCESS	
					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap]	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	.		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	11	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		1										
Operator												
Material						ļ						
Setup												
Other												
Process	_											
Supplier												
Training					•							
Unapproved	'	<u> </u>								L		
						AUL	T CATE	GORY				
Landii	ng Gear			_	General					1	Г	7_
	Bending			., -	Bend	\vdash	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Conce	ntric to (^{D/S} -	BOM/Route	-	Hardwa		-	Over/Under	-	Temperature/Cure
	Cracks	1 0 ·			Broken/Damaged	-		ion Incomplete		Part Incorre		Weld
	Crushed	Crimped			Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs	_			Contamination	\vdash	Mainte			Part Moved	14	
	Heat Tre		. T., le -	 	Countersink	-	Mislabe		<u> </u>	Positioned V		Joshan
	— `	n Strip in	lupe	 	Cut Too Short	1	Misread	1	L_	Power Loss/	ourge	Other
	Ripples in			_	Drill Holes	-	Offset	Calibratia -				
	—	Vaves in I		' ⊢	Drawing	\vdash		Calibration				
	Lurning :	Sequence	!	- 1	Finish	1	Out of 3	Sequence				

Outside Dimensions

DQA:___

Date:

Wave/Twist in Tube

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Work	Orde	r ID	101	776
WUIK	Ol uti	ענו	101	. / / U

May-13-13 1:13:59 PM

Hand Finishing

101776

Page 2

Accept Item ID: D3883-1 *N900040100* Setup Start Revision ID: Stop Item Name: Saddle, Outboard LH Start Oty: 6.00 Start Date: 5/14/13 **Cust Item ID: Reg'd Oty:** 6.00 Required Date: 5/20/13 **Customer:** Réference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): OC: Date: Reject Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Insp. Qty Qty Number Stamp Work Center ID Code Description **Run Hours** OC2- Inspect parts off machine FAI/FAIB 0.00 110 OAS 40 9-89 *110* 13/07/5 0.00 Memo Quality Control and 13/07/17 0.00 QC8- Inspect parts - second check -*120* 0.00 Memo **Quality Control** Chemical Conversion Coat per QSI005 4.1 0.00 76 13718 *120* 0.00 HandFinish Memo

NCR:	⁄es	/ No				WORK ORDER NON-C	O	VFORM	AANCE / UPDATE			_		
						T					QA Closed:	D	ate:	
Work Orde	er: .					DISPOSITION	,			_	PARTMENT,		. —	.
Part N	۷o. ِ	:	:			Rework Scrap Use-as-is		r	Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Je d. Eng. Coo re/Packagin	r. 🗌	Engineering Quality Other
NCR I	No.					Work Order Update			Large Fab Composite	_		Supplie	~ —	
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verificati	on	QC Inspector
Doc/Data		i				•								
Equip/Tooling	Ш	;												
Operator											1			
Material							1							
Setup								*						
Other														
Process														
Supplier														
Training									,					
Unapproved						•						<u> </u>		
			·			F	AUL	LT CATE	GORY					
Landi	ng (Gear			_	General	_	_			•			•
	$oxed{oxed}$	Bending				Bend		Grain		\perp	Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	<u></u>	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete	_	Part Incorre	ct		Weld
	L	Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	L	Cuffs				Contamination		Mainte	nance	L	Part Moved			
		Heat Trea	at		. [Countersink		Mislabe	led		Positioned V	V rong		•
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge		Other
		Ripples in	n Bend			Drill Holes		Offset						
		Torque W	Vaves in E	Extrusio	n 🗍	Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Packaging

Packaging

Page 3

Mav-13-13 1:13:59 PM D3883-1 Item ID: *N900040100* Setup Start Revision ID: Stop Item Name: Saddle, Outboard LH Start Otv: 6.00 Start Date: 5/14/13 **Cust Item ID:** Required Date: 5/20/13 Reg'd Qty: 6.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop SPC (Y/N): Date: Date: QC: Tool ID Tool # Plan Reject Reject Insp. Set Up/ Accept Sequence ID/ Operation Oty Number Stamp Code **Qty** Work Center ID Description **Run Hours** White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 M 1256DO *140* 0.00 Powdercoat Memo START TIME: Powder Coating OVEN TEMPERATURE FINISH TIME: 0.00 150 OC3- Inspect Part Finish *150* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 5T429 6x M. N. 13-07-24

0.00

Memo

NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	MANCE / UP	DATE	QA Closed:	Date	:
Work Orde	ri.				DISPOSITION				AGAINST DE			
Part N		:			Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	In	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data		1				1						
Equip/Tooling		1										
Operator												
Material												
Setup												
Other		1				1						
Process												
Supplier		1										
Training												
Unapproved		<u>.l</u>						<u></u>				
		:			i e		CATE	GORY				
Landii	ng Gear			_	General					1	r-	
	Bending				Bend	\mathbf{H}	Grain		-	Ovalized	-	Pressure/Forced
		lot Conce	ntric to	^{0/s} -	BOM/Route	 -	Hardwa		<u> </u>	Over/Under	<u> </u>	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	•	ion Incomplete		Part Incorred	<u></u> -	Weld
	—	/Crimped			Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash		enance	<u> </u>	Part Moved		
	Heat Tre			-	Countersink	\vdash	Vislabe		<u> </u>	Positioned V		T _{out} .
	—	on Strip ir	Tube	 	Cut Too Short	\vdash	Visread	d .		Power Loss/	Surge	Other
	Ripples			<u> </u>	Drill Holes	\vdash	Offset	- 111 ··				
	—	Waves in		ⁿ	Drawing	-		Calibration				
	Turning	Sequence	<u> </u>	l	Finish	1 (Out of S	Sequence				

Outside Dimensions

DQA:

Date: ___

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-13-13 1:13:59 PM

Item ID:

D3883-1

5/14/13

Accept

N900040100

Setup Start

Revision ID:

Item Name: **Start Date:**

Saddle, Outboard LH

Cust Item ID:

Required Date: 5/20/13

Start Qty: 6.00 Rea'd Otv: 6.00

Customer:

Reference:

Approvals:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

170

OC21- Final Inspection - Work Order Release

0.00

170

OC

Memo

0.00

pt Reject
Qty Nu...

MLJ 13-07-26

MK
13-7-24

Quality Control

										DQA:	Date:	**** <u>)</u>	
NCR: Yes	/ No				WORK ORDER NON-C	ON	FORN	MANCE / UP	DATE	QA Closed:	Date:	₩,	
Work Order:					DISPOSITION			·	AGAINST DE	PARTMENT	/PROCESS	*	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descrip	otion of work order update	In	nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other													

Landing G	Gear	General		_	
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Process
Supplier
Training
Unapproved

May-13-13 1:13:59 PM

Work Order ID:

101776

Parent Item:

D3883-1

Parent Item Name:

Saddle, Outboard LH

Start Date: 5/14/13

Required Date: 5/20/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

Comments:	IPP RevA: New ISS	de DD vermed by:	EC .										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 Saddle Billet		Manufactured	No			100	Each	21.0000	1	6	(A)	13/07/	15
				Location		Loc Oty	<u>Lo</u>	c Code			\ 9 _89		
				MAT040		1							
				93790)	1				<u> </u>			
	.7.			MAT046		20							
				99146	5	20							
				-R 1020	727				1	1			
				-R 1020 -D 1024	193				L	†			

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Engineering Water Jet Rework Prod. Eng. Coor. Quality Machining Part No. Scrap Small Fab Rec/Store/Packaging Other Thermoforming Finishing Use-as-is NCR No. Large Fab Composite Supplier Work Order Update Description of work order update Sign & Initial Action Root or Non-conformance Chief Eng Description Date Verification QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Burrs Instructions Incomplete/Unclear Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

DART AEROSPACE LTD	Work Order:	101776
Description: Saddle, Outboard, LH	Part Number:	D3883-1
Inspection Dwg: D3883 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Re					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	2.870	2.880		2 875	2875	2.875	2.875	1 1	
В	1.433	1.443		1438	1.438	17.438	1.438	†	
С	0.638	0.658		. 648	-648	648	648		
D	3.895	3.905		3,900	3-900	3.900	3.900		
Ε	0.257	0.262		.258	258	258	258		
F	0.605	0.625		.615	-616	-616	-616		
G	1.120	1.130		1.125	11-125	11-125	125		
Н	2.245	2.255		2.250	2.250	2.250	2250	 	
l	2.000	2.020		2.0008	2.001	2.004	2.003		
J	0.140	0.165		. 148	ISI	-152	- 151	†	
K	0.240	0.260		. 246	251	251	1-253	1	
L	0.115	0.135		.123	119	125	125	 	
М	0.140	0.165		145	1 149	-149	-150	 	
N	0.720	0.780		.780	-780	-780	-180	 	
0	0.240	0.260		. 247	252	251	253	 	
Р	0.110	0.140		,140	-140	12140	-140		
Q	0.178	0.198		188	-188	-188	188	1	
R	2.825	2.885		2.865	2.865	2,865	2-865		
S	0.316	0.321		. 316	-316	-316	-316		
Т	0.990	1.010		1,007	1-001	1.001	1,001	 	
U	1.745	1.755		1,750	1-750	1.750	1-750		
V	5.990	6.010		6.003	6.001	6.000	6.000		
W	1.245	1.255		6.003	1250	1250	1-250	-	
Х	0.490	0.510		.501	-503	-502	-501		
Y	1.220	1.280		1,250	7 250	1,250	1.250		
Z	2.495	2.505		2,500	2,500	2.500	2.500		· · · · · · · · · · · · · · · · · · ·
AA	0.313	0.318		314	-314	-314	-314		j.
AB	0.020	0.040		-030	-030	-030	-030		<i>y</i>
AC	0.760	0.765		. 760	-760	- 460	-760	 	
AD	0.215	0.220		·11x	117	217	217	-	
AE	1.265	1.285	N ,	1.2658	1.266	1269	7.268		
AF			2.7%	112000	1.200	V-001	/ - X W X		
1	Acc	ept/Reje	ct OAS			-			• .
			V			L			

	40	į.			
Measured by:	9-89	175	Audited by	C112	
Date:	13/07/15	13-7-16	Date:	13/07/17	

A 09.10.22 New Issue	Rev	Date	Change	Revised by	Approved
B 09 11 25 Dimension AE added	Α	09.10.22	New Issue	KJ .	JLM /
	В	09.11.25	Dimension AE added	<u> </u>	

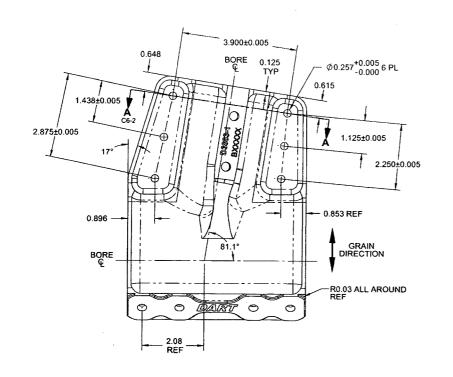
DART AEROSPACE LTD	Work Order:	101776	
Description: Saddle, Outboard, LH	Part Number:	D3883-1	
Inspection Dwg: D3883 Rev. C		Page 1 of 1	

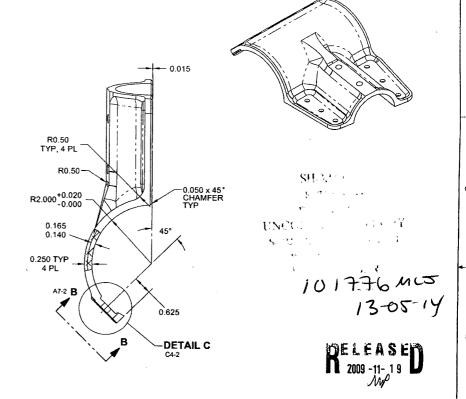
Inspect dimensions highlighted on inspection sheet drawing and record below:

			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	15	\$6	3	4	Ву	Date
Α	2.870	2.880		2-875	2.875			+ +	
В	1.433	1.443		1.438	1.438				
С	0.638	0.658		- 649	-649				-
D	3.895	3.905		3.900	3.900				
Е	0.257	0.262		- 258	258				
F	0.605	0.625		-617	-617				
G	1.120	1.130		1125	11125				
H	2.245	2.255		12250	2,250			1	
	2.000	2.020		Q-004	2-004				
J	0.140	0.165		-150	-150				
K	0.240	0.260		-251	-250			1 -	
L	0.115	0.135		-126	-126			1	
M	0.140	0.165		-148	-149				
N	0.720	0.780		-780	-780				•
0	0.240	0.260		250	.249			1	·
Р	0.110	0.140		_ 140	-140		· · · · · · · · · · · · · · · · · · ·		
Q	0.178	0.198		-140 -188	-188				
R	2.825	2.885		2.865	2-865				
S	0.316	0.321		-316	-316				
Т	0.990	1.010		1001	1-001			1	
U.	1.745	1.755		1.750	1.750			1	
V	5.990	6.010		6.000	6-000			 	·
W	1.245	1.255		1-250	1.250				
Χ	0.490	0.510	***************************************	-501	- 502			 	
Υ	1.220	1.280		1-250	1.250				
Ζ	2.495	2.505		2,500	2.500			 	
AA	0.313	0.318		-34	-314			1	
AB	0.020	0.040		- 030	-030			 	
AC	0.760	0.765		-760	460				
AD	0.215	0.220		-217	-217		· <u></u>	† †-	
AE	1.265	1.285		1269	1-269			 	
AF					/ • • • • • • • • • • • • • • • • • • •				· · · · · · · · · · · · · · · · · · ·
	Acc	ept/Rejec	t						

Measured by:	Audited by	and		
Date: 13-7-16	Date:	13/0	7/12	

Rev	Date	Change	Revi	sed by	Approved
Α	09.10.22	New Issue	KJ		JLM /
В	09.11.25	Dimension AE added	KJ	\$1	
				//)	- Confessor





D3883-1 SADDLE, OUTBOARD LH (SHOWN) D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

NOTES:
1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010

7) WEIGHT: 1.00 lbs 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

ADD R1.265 (ZN D6-2) 09.11.09 D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2 09.06.30 Α RF 09.03.30 REV. DESCRIPTION BY DATE DESIGN RF DART AEROSPACE USA, INC. DRAWN RF PORT HADLOCK, WA CHECKED DRAWING NO. REV. C D3883 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE DE APPR. **OUTBOARD SADDLE** NTS COPYRIGHT @ 2009 BY DART AEROSPACE USA, INC DATE 09.11.09

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